

Work Order ID 75818

\*75818\*

Page 1

October 31-11 12:43:26 PM

Item ID: D2330-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Frame

Start Date: 31/10/2011 Start Qty: 1.00

Required Date: 14/11/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 11/10/13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2330	H								

100

0.00

\*100\*

Large Fab

Memo

Large Fab

1- Cut tube as per dwg D2330  
2- remove identification marks and deburr

0.00

110

0.00

\*110\*

QC

QC5- Inspect part completeness to step on W/O

Memo

Quality Control

0.00

120

0.00

\*120\*

Packaging

Identify as per dwg &amp; Stock Location: WA

Memo

Packaging

0.00

W/O: 75818		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-02-08	110	change to Qc 6	PC AA	12-02-08 12-02-08			S 12/02/09

Part No: D2330-5 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID: 75818

\*75818\*

Page 2

October 31 - 12:43:26 PM

Item ID: D2330-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Frame

Start Date: 31/10/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 14/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
*130*									
QC	Memo	0.00							
Quality Control									

M.L.J 12/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October-31-11 12:43:31 PM

Page 1

Work Order ID: 75818

\*75818\*

Parent Item: D2330-5

\*D2330-5\*

Parent Item Name: Frame

Start Date: 31/10/2011

Required Date: 14/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 10.09.08 new issue DD verf:EC  
10.11.30 AS PER DWG REV.H DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

506.7499

2.88

3.031579

**\*M304TS0 750W 065\***

304 SQ Tube .75x.75x.065W

\*\*

*Cpl 12.02.08*

Location

Loc Qty

Loc Code

MAT018

485.0857585

117636

67.9987

118773

417.087059

WA

6.0667

118181

6.0667

WA007

15.5974906

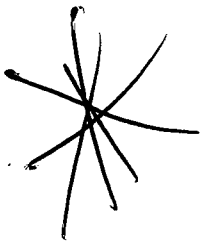
116267

14.628472

116763

0.9690186

*12.12.6316*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 25818 M.L.J

11/10/3

RELEASED  
2010-11-25

- NOTES:**  
1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065  
2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF. DART SPEC M304EX0.75-16F  
3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3  
4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: N/A  
7) IDENTIFICATION: N/A  
8) WEIGHT: N/A  
9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. H
CHECKED		D2330	SHEET 1 OF 6
MFG. APPR.		TITLE	SCALE
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DATE	10.09.28		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

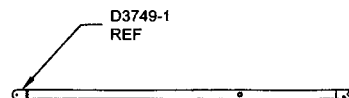
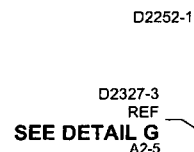
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8 7 6 5 4 3 2








84.00±0.13

**D2330-043 LID FRAME**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

**D2330-043 LID FRAME**

RELEASED  
2010-11-25

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 2 OF 6
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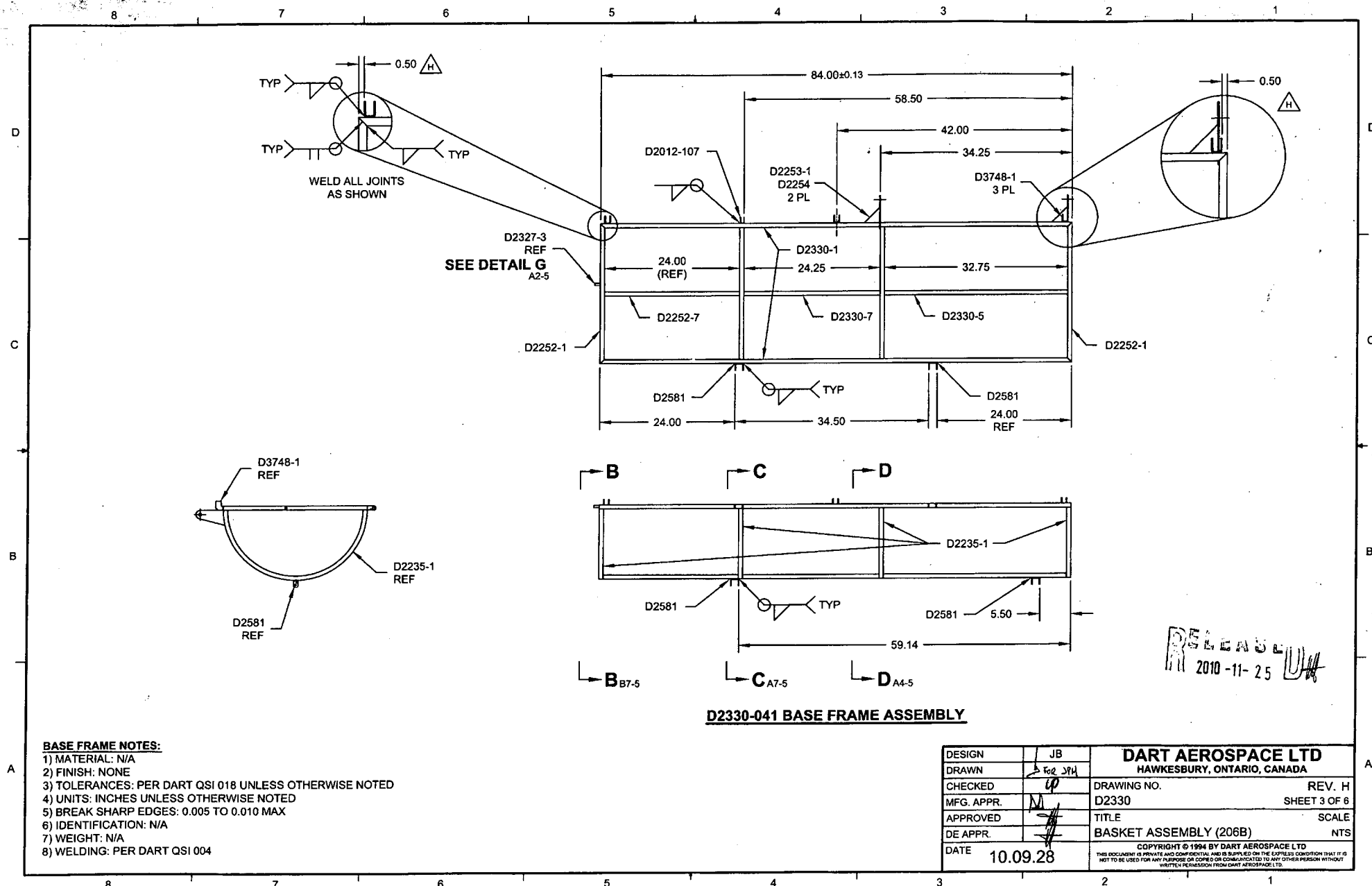
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

75818



**D2330-041 BASE FRAME ASSEMBLY**

**BASE FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	For JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. H
MFG. APPR.	M	D2330	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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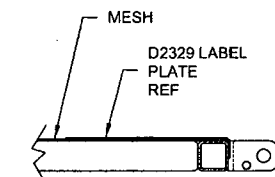
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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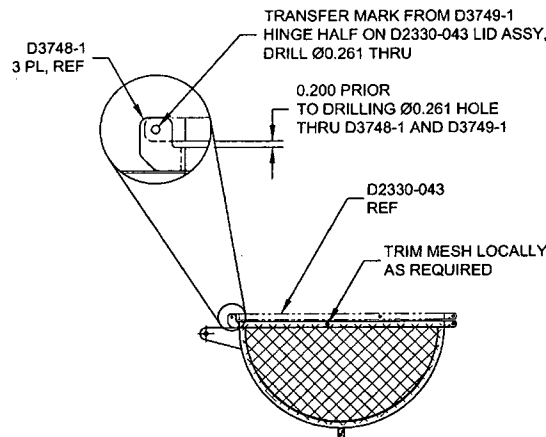
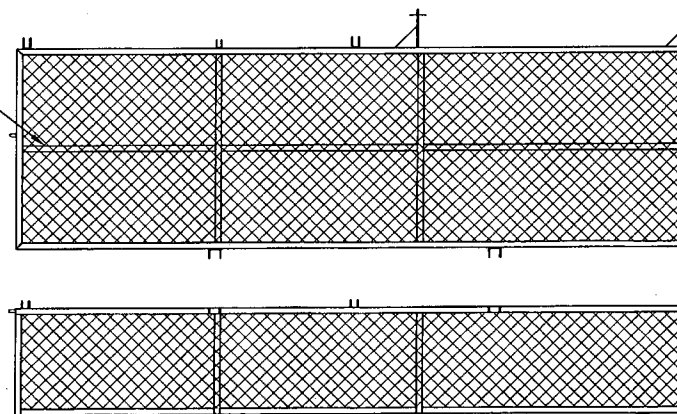
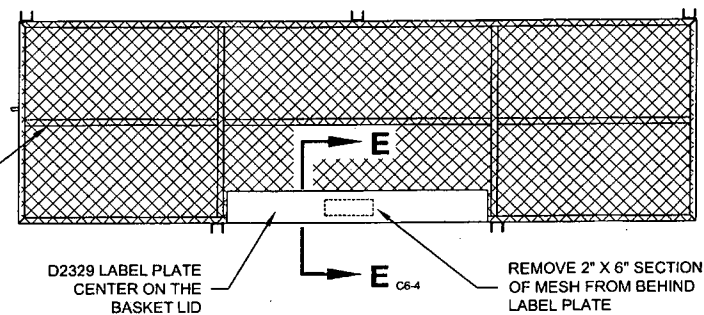
**NOTE:** Date & initial all entries

75818



**SECTION E-E**  
VIEW ROTATED 90° CCW

TACK WELD EACH STRAND END OF MESH TO FRAME



**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. H
MFG. APPR.	JB	D2330	SHEET 4 OF 6
APPROVED	JB	TITLE	SCALE
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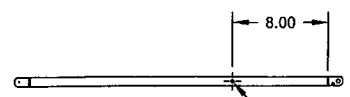
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

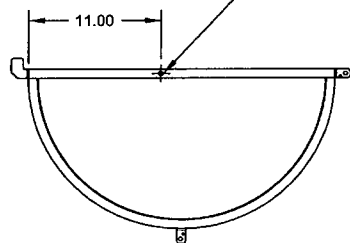
**NOTE:** Date & initial all entries

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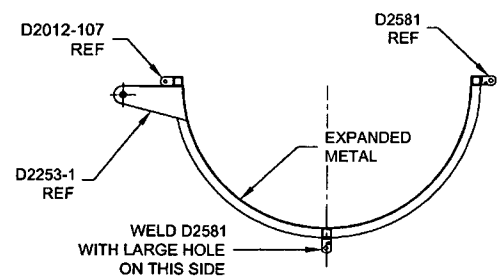


**VIEW A-A** A6-2

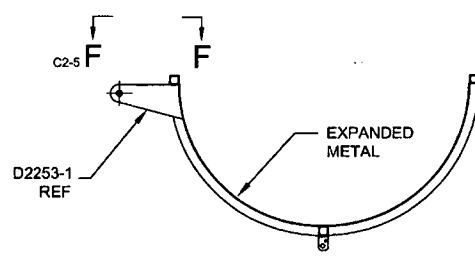
DRILL 3/8 HOLE AND  
INSTALL D2327-3  
SEE DETAIL G A2-5



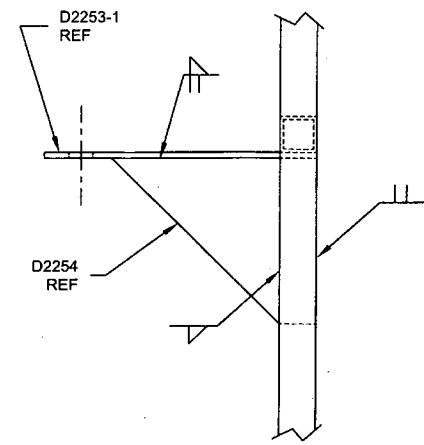
**VIEW B-B** A5-3



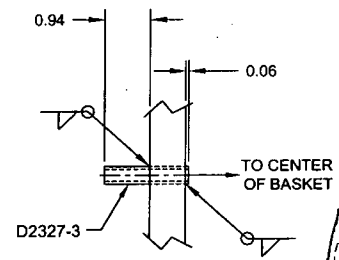
**SECTION C-C** A4-3



**SECTION D-D** A3-3







**VIEW F-F** B6-5  
SCALE 4X



**DETAIL G**  
SPACER INSTALLATION  
SCALE 4X

RELEASED  
2010-11-25

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	PER JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 5 OF 6
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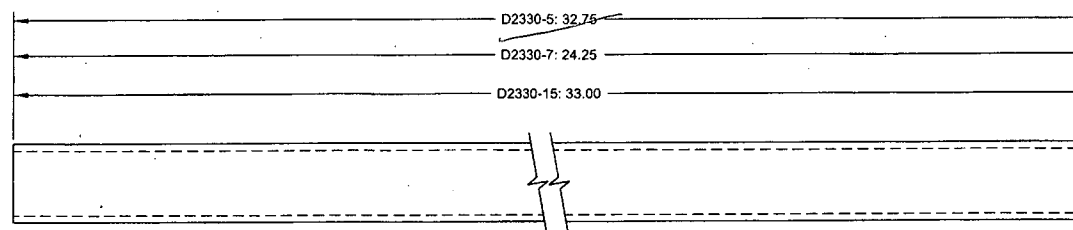
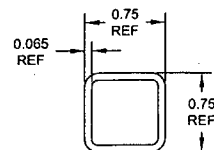
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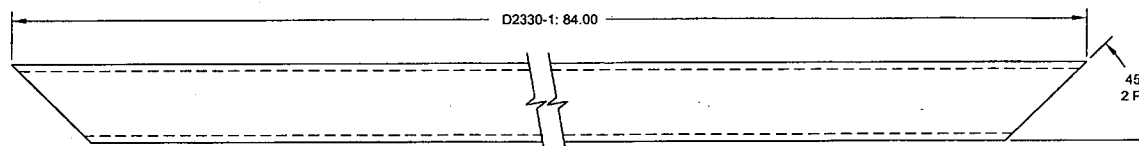
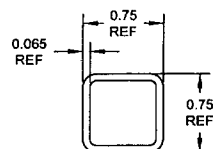
**NOTE:** Date & initial all entries



75818



D2330-5 FRAME  
D2330-7 FRAME  
D2330-15 FRAME



D2330-1 FRAME

RELEASED  
2010-11-25

**NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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